Page 1

Work Order ID 70821 ->

Wednesday, June 15, 2011 2:28:12 PM



Accept D3405-043 Setup Start Item ID: Revision ID: Stop Lug Assembly Item Name: Start Qty: 10.00 6/15/2011 Start Date: Cust Item ID: Req'd Qty: 10.00 Required Date: 6/22/2011 Customer: Reference: Start Run Date://-0/-/5 Tooling: Date: Process Plan: Approvals: Stop Date: QC: SPC (Y/N): Date: Reject Reject Insp. Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Stamp Qty Qty Number Work Center ID Description Code Run Hours Revision Nbr Draw Nbr Rev B D3405 0.00 100 FLOW WATER JET 1B11-6-16 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dwg D3405 Dwg Rev: 304.125 Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110 1311-6-16 0.00 Memo Quality Control

120

Memo

QC8- Inspect parts - second check

Quality Control

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-				
Part No	.	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\; <u> </u>	_ Date: _	
	R	esolution:	Disposition	1:	QA: N/C Clo	sed:		Date:	
NCR:		1	WORK ORDI	ER NON-CONFORMA	NCE (NCR				x =
DATE	STEP	Description of NC		Corrective Action Secti		Verific	ation	Date: Date: Date:	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section			QC Inspector
						100			
						1100			

Work Order ID 70821

Wednesday, June 15, 2011 2:28:12 PM

Item ID:

D3405-043

Revision ID:

Lug Assembly Item Name:

Start Date:

6/15/2011

Start Qty: 10.00



Accept



Setup Start



Stop

Required Date: 6/22/2011

Req'd Qty: 10.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Reject

Qty

QC:

Date:

SPC (Y/N):

Date:

Tool#

Plan

Code

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ Work Center ID

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo 1-Deburr

Memo

2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming Set Up/ Run Hours

0.00

0.00

SB 1166/17

15

Qty

Accept

Quality Control

OC5- Inspect part completeness to step on W/O

150

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: MH 7659 0.00

Large Fab

Weld as per Dwg D3405 use DT8484 Identify as D3405-043

0.00

W/O:			WO	RK ORDER CHANG	ES				,
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	۱:	_ Date: _	
		solution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			-
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Date: on Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section			QC Inspector
						19			
						45			-
							117		
								5397	
						1,3			

Work Order ID 70821

Wednesday, June 15, 2011 2:28:12 PM

D3405-043

Accept

Setup Start

Stop

Revision ID:

Item ID:

Lug Assembly Item Name:

Required Date: 6/22/2011

6/15/2011

Start Qty: 10.00

Req'd Qty: 10.00

Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Process Plan: Approvals:

Date:

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation

OC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

0.00

Tool#

Plan Code Accept Oty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

Description

QC9-Inspect visual per QS1004-Fusion Welds

Memo

0.00

0.00

0.00

Sul08/75

180

Powdercoat

Powder Coating

White Gloss(Ref;4.3.5.1) per QS1005 4.3-Alum 7:0000 F

Memo

Memo

START TIME: OVEN TEMPERATURE:

FINISH TIME:

5x amelup

W/O:			V	ORK ORDER CHANG	GES			- Allei	ELSE.	
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	_ NCI	R: Yes	No DQ	λ:	_ Date: _	
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NCR:		an e 11 an 1	WORK OR	DER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			ction B		Verific	ation	Date:	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section			QC Inspector
							1778			
							190			
							15			
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							13/1		17.6	
							100		Turk .	
			- 9				115		T. Comment	

Work Order ID 70821

Wednesday, June 15, 2011 2:28:12 PM

Item ID:

D3405-043

Accept

Setup Start

Stop



Revision ID:

Item Name: Lug Assembly

Required Date: 6/22/2011

Start Date:

6/15/2011

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Process Plan: Approvals:

QC:

Date:

Tooling:

Date:

Tool#

Start Run

Stop



Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Plan Code Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

200

Packaging

Packaging

Identify as per dwg & Stock Location: ST 4749.

Memo

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

M11281291

W/O:			WO	RK ORDER CHAN	GES			127		
DATE	STEP	PR	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							19			
						CR: Yes No DQA: A: N/C Closed: E (NCR) Sign & Verification Section C				
							Closed:CR) Verification Section C			
										1 .
Part No	:	PAR #:	Fault Categ	jory:	NC	R: Yes I	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	:	QA:	N/C Cld	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCR)			
	STEP	Description of NC		The second secon	ection B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	n				Chief Eng	QC Inspector
		a =			₹ *				121	
		4								

Picklist Print

Wednesday, June 15, 2011 2:28:19 PM

Work Order ID: 70821

Parent Item:

D3405-043

Parent Item Name: Lug Assembly



Start Date: 6/15/2011

Start Qty: 10.00

Required Date: 6/22/2011

Page 1

Required Qty: 10.00

IPP A 05.09.01 New issue: KJ/JLM

Purchased

IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	35.0000		10 Æ	16-8	v-24	<u> </u>

Comments:

72326 X5

No

WA 69883 WA030 67127

Location

Loc Code

127.0000

0.154 1.621053

M304S11GA

304/316 0.125 Sheet

Loc Oty Location 127 MAT020

117494 127 Loc Code

117494

B 72073 X4

11-8-24.

		WC	RK ORDER CHAN	GES				
STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					100			
:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
Re	esolution:	Disposition	n:	QA: N/C CI	osed:		Date: _	
		WORK ORDI	ER NON-CONFORM	ANCE (NCF	1)			
CTED	Description of NC				Verific	cation	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8			Chief Eng	QC Inspector
					117			
		PAR #:	PAR #: Fault Cates Resolution: Disposition WORK ORDI STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Section A Corrective Action Description	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C Cl WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A Section B Initial Action Description Sign 8	PAR #: Fault Category: NCR: Yes No DQ. Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

DART AEROSPACE LTD	Work Order:	70821
Description: GHW Bracket	Part Number:	D3405-3
Inspection Dwg: D3405 Rev: B		Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comm	ents
Ø0.438	+0.006/-0.001	439	32		V 802		
1.50	+/-0.030	1.503	8		U		
1.750	+/-0.010	1.747	3		ν		=======================================
R0.63	+/-0.030	.63	>		V		
3.00	+/-0.030	3, 🕉	5		V		
8.00	+/-0.030	8.002	5		٧		
6.751	+/-0.005	6.755	7		V		
		Audited by	1		Prototype Ap		N/A

	Violen	Audited by:	Prototype Approval:	N/A
Measured by:	B	Audited by.		ALIA
Date:	11-6-16	Date: 11/06/16	Date:	N/A

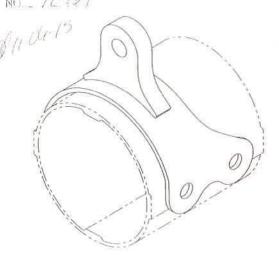
	Data	Change		Revised by	Approved
Rev	Date	Y	-12 -2010-010	KJ/JLM ,	// //
A	06.09.01	11011 10000	P/O D3405-043		111
В	09.05.04	Dimensions update p	er Dwg Rev. B	KJ/DD 78	July

W/O:			W	ORK ORDER CHANG	SES				•
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector
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						100			
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	
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NCR:		1	WORK ORD	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC		The state of the s	tion B	Verific	cation	Approval	Approval
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						120			
						1			
		>				42			
						1		HEE	
						30			
						1			

QTY. QTY. -043 ITEM PART NUMBER DESCRIPTION LUG ASSEMBLY D3405-041 X LUG ASSEMBLY D3405-043 X 2 GHW LUG D3404-1 11 GHW BRACKET D3405-1 12 D3405-3 GHW BRACKET 13

D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

SHKH RUTHEN IS ENGLISHED UNCONTROLLED SUBJECT TO AMERICAN IS WITHOUT BOTH WORK OR NO.



D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSPERED TO "B" SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INST. (SEE PAR198) SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. 08.09.19 05,03,08 NEW ISSUE DATE BY DESCRIPTION REV. DART AEROSPACE LTD DESIGN HAWKESBURY, ONTARIO, CANADA DRAWN REV. B DRAWING NO. CHECKED D3405 SHEET 1 OF 4 MFG. APPR. SCALE APPROVED GHW LUG ASSEMBLY NTS DE APPR COPYRIGHT O 2005 BY DART AEROSPACE LTD

JHS DOD-HER OF REPRESENDED OF COMMISSION OF BURESTS CONFORM
HER TORK USED FOR KIN PARKED OF COMMISSION OF COMMISSION OF BURESTS OF PROPERTY. DATE 08.09.19

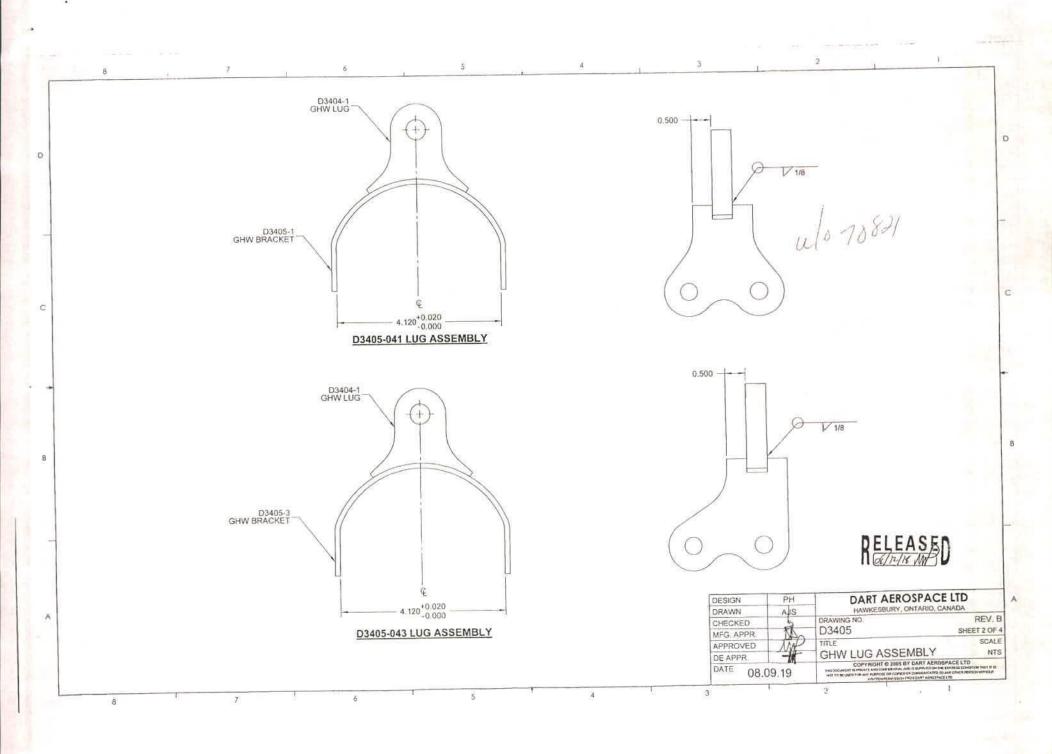
D

1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER:
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

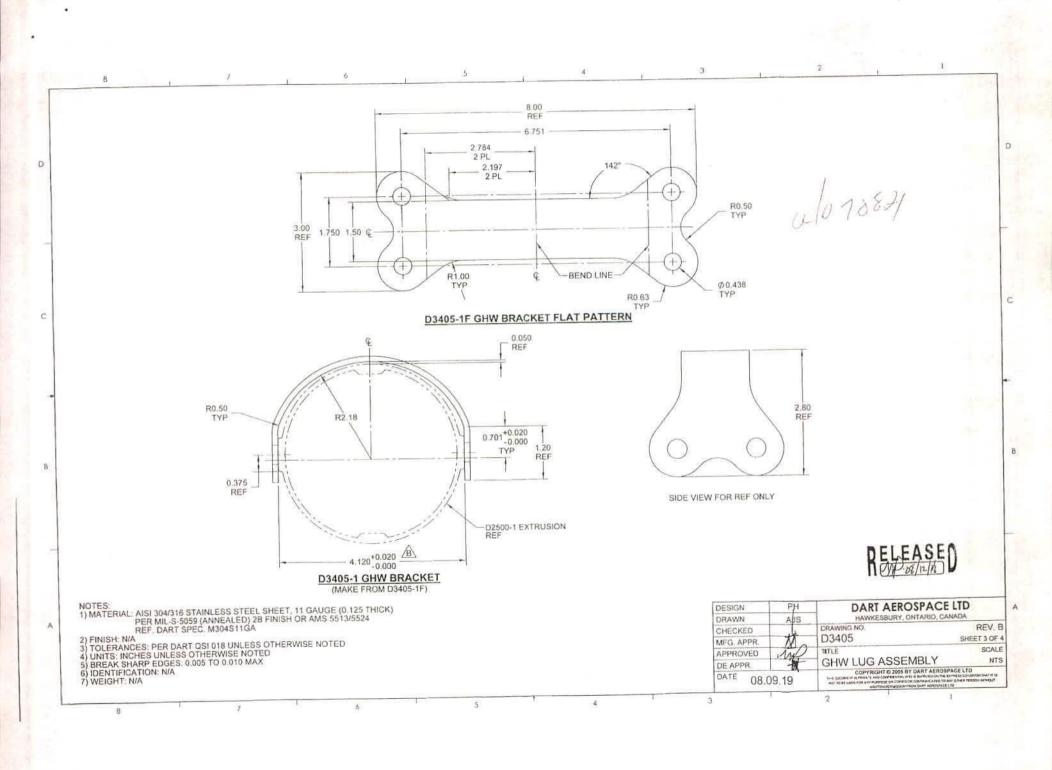
7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

B

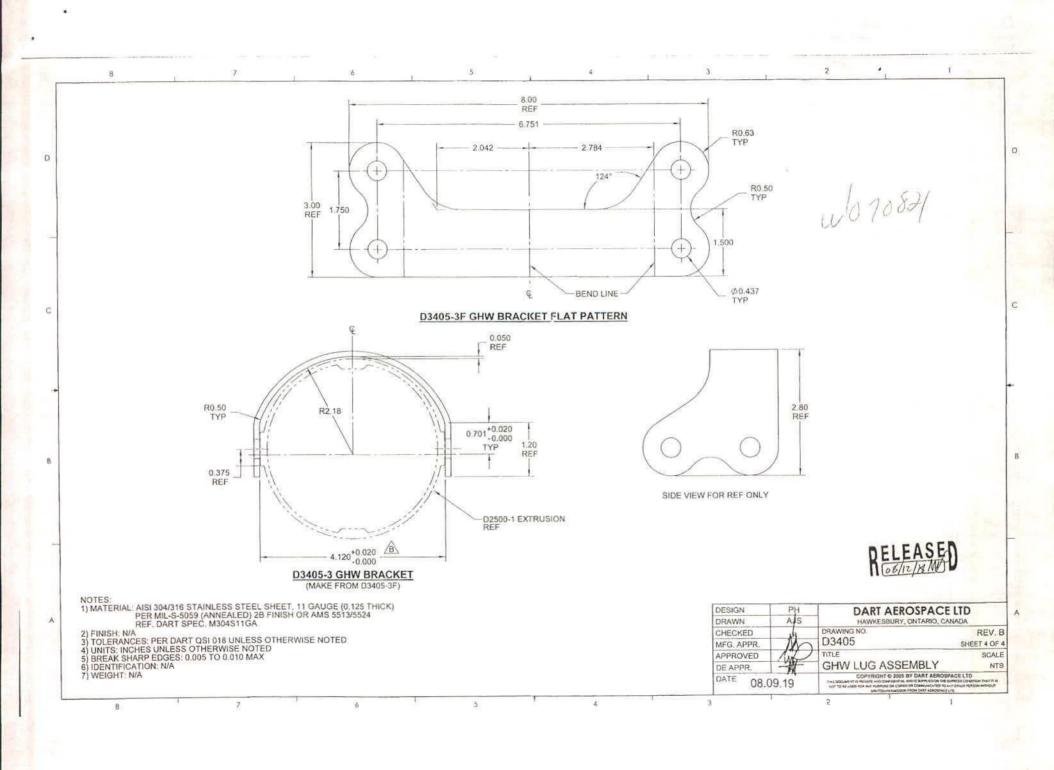
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DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)				
		Description of NC		Corrective Action Section	on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							TE	r rod mgr			
								Fig. 1			
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:						
Resolution:			Disposition: QA: N/C Closed:					Date:			
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)					
	0755	Description of NC			ion B	Verification		Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	ion C	Chief Eng	QC Inspector		
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								200			



		WO	RK ORDER CHANG	ES					
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STEP	Description of NC Section A	Corrective Action Section B			Verific	ation	Annroyal	Approval	
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W/O:			WC	RK ORDER CHAN	GES			146	per property		
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	NCR:	NCR: Yes No DQA: Date:						
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